



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RB23007615-23
Job Sheet 178443



Part No: RB23007615-23

Job Qty: 46 ea

Part Name: Socket Head Cap Screw



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 5/31/18

Job Tracking No:

Due Date: 10/10/18

Created By: Logan David

Type: SOLD

Description:

Note: DWG RB23007615 REV B IPP REV A 18.02.20 NEW ISSUE FK VERIFY DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	46 Ea	10/10/18	10/10/18	0.00	0.00	Start Up Machining-3		
110	CNC Lathe	46 pcs	10/10/18	10/10/18	0.00	23.00	MORI SL-154		See attached →
120	QC	46 pcs	10/10/18	10/10/18	0.00	0.00	QC2 Machining-4		
130	QC	46 pcs	10/10/18	10/10/18	0.00	0.00	QC8 Machining-4		
131	Outsource	46 pcs	10/10/18	10/10/18	0.00	0.00	Outsource12		18-10-20 OCT 23 2018
132	Packaging	46 pcs	10/10/18	10/10/18	0.00	0.00	Packaging2		OCT 26 2018
133	QC	46 pcs	10/10/18	10/10/18	0.00	0.00	QC6		38
140	Packaging	46 pcs	10/10/18	10/10/18	0.00	0.00	Packaging3-1		3-89
150	QC21-SA	46 Ea	10/10/18	10/10/18	0.00	0.00	QC21		21 OCT 30 2018

Part Op 110 - 1-Machine as per DWG. FC034 FOLIO REV: _____ DWG REV: _____ 2-Debur

Descriptions: 131 - -Issue P/O to GROUPE ALTECH; PO 041419 -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; Steel -Certificate of Conformity is required

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
91251A435	Socket Head Cap Screw	46 Ea (1 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	91251A435	46	0	0

Part Specifications

Specifications could not be found.

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RB23007615-23
Job Sheet 178443



Part No: RB23007615-23

Job Qty: 24 ea

Part Name: Socket Head Cap Screw



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 5/31/18

Job Tracking No:

Due Date: 7/24/18

Created By: Logan David

Type: SOLD

Description:

Note: DWG RB23007615 REV B IPP REV A 18.02.20 NEW ISSUE FK VERIFY DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	24 Ea	7/24/18	7/24/18	0.00	0.00	Start Up Machining-3		18/10/19
110	CNC Lathe	24 pcs	7/24/18	7/24/18	0.00	12.00	MORI SL-154		18/10/19
120	QC	24 pcs	7/24/18	7/24/18	0.00	0.00	QC2 Machining-4		18/10/19
130	QC	24 pcs	7/24/18	7/24/18	0.00	0.00	QC8 Machining-4		18/10/19
140	Packaging	24 pcs	7/24/18	7/24/18	0.00	0.00	Packaging3-1		De 18-10-20
150	QC21-SA	24 Ea	7/24/18	7/24/18	0.00	0.00	QC21		

Part Op
Descriptions: 110 - 1-Machine as per DWG. FC034 FOLIO REV: _____ DWG REV: _____ 2-Deburr

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
91251A435	Socket Head Cap Screw	24 Ea (1 ea)	90-Start up Operation	5019010

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	91251A435	24	50	0

Part Specifications

Specifications could not be found.

Plex 7/24/18 4:10 PM dart.logan.david



Container No: S119953



Part: RB23007615-23

Job No: 178443

Serial No/Batch: S119953

Revision: B

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 10/20/18

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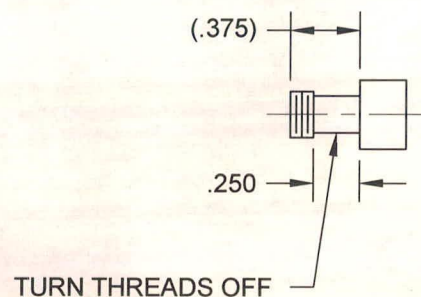
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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
B	-23 ADDED TO SEPARATE SHEET.	2/3/14	DPD	RW

TEO ATTACHED



-23

MOUNT SCREWS

RED BARN MACHINE	
TITLE POWER TURBINE CLEANING KIT	
DWG NO. RB23007615-23	REV B
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON:	
DECIMALS	
.XXX ± .005	FRACTIONS ± 1/32
.XX ± .01	ANGLES ± 5°
.X ± .1	
UNLESS OTHERWISE SPECIFIED	
1. BREAK ALL SHARP EDGES	
.015 x 45° PR .015 R	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 1:1	DATE 2-1-01
SHEET 5 of 7	
DRAWN BY: COLE	
APPROVED: <i>D. Wed</i>	
TREAT: BLACK OXIDE	
FINISH: BLACK OXIDE	
SPEC: USED ON MODEL	
ALLISON C30	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA/Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging Supplier ☐ Engineering Quality ☐ Other ☐				
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval	
Description Work Order Deviation				Disposition			Completed By	
							Lead hand / Supervisor Approval Verification	
							QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐						
		OTHER : ☐						



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Tel (613) 632-5200

PURCHASE ORDER **PO041419**

Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO041419
PO Date: 10/23/18
Due Date: 10/26/18
Purchase Order Revision:
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pynt Terms: Net 60
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	179997	RB6796941-15	Guide -Issue P/O to GROUPE ALTECH; PO -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; Stress Proof -Certificate of Conformity is required	Firmed	-	10/31/18	10 pcs	0 pcs	10 pcs	\$2.1428571/pcs	\$21.43

10 x OCT 26 2018



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PURCHASE ORDER **PO041419**

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
2	178443	RB23007615-23	Socket Head Cap Screw -Issue P/O to GROUPE ALTECH; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; Steel -Certificate of Conformity is required	Firmed	-	10/31/18	46 pcs	0 pcs	46 pcs	\$2.1428571/pcs	\$98.57
Grand Total:											\$120.00

Order Notes

Procurement Quality Clauses
 A005 right of entry
 A012 chemical and physical test report
 A016 personnel qualification
 A017 raw material identification (as applicable)

A022 Apical Processing
 A024 process certifications
 A026 certification of material conformance

A041 quality management system
 A042 dart notification by supplier
 A043 retension of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 10/24/18 11:35 AM dart.tsimiklis.chrisoula



Certificat de Conformité / Certificate of Compliance

(013786-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

013786 - 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
25-Oct-2018		Aman		041419 ✓				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	RB6796941-15 Rev. ✓	RB6796941-15 01 -OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY A THIN LAYER OF OIL AS PER MIL-PRF-16173 GRADE 3 CLASS 1 WIPE OFF EXCESS OIL	BLACK-OXIDE CH	10	✓ 10	0	0	0
2	RB23007615-23 Rev. ✓	RB23007615-23 01 -OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY A THIN LAYER OF OIL AS PER MIL-PRF-16173 GRADE 3 CLAS	OXIDE-BLACK CH	46	✓ 46	0	0	0

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Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness
Inspecteur Qualité
Quality Inspector
Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.

